Wednesday, 3/14/2007 3:31:22 PM SPLIT-2 . User: Kim Johnston **Process Sheet Drawing Name** : BUSHING Customer : CU-DAR001 Dart Helicopters Services Job Number : 31224 - 2 : 10175 **Estimate Number** : D2570 : NIA Part Number P.O. Number S.O. No. : NA : D2570 REV A This Issue : 3/14/2007 **Drawing Number** : NC : N/A Prsht Rev. Project Number : 3/14/2007 : MACHINED PARTS First Issue Type **Drawing Revision** : A : NIA : 30811 Material **Previous Run** : 3/30/2007 500 Um: Each Due Date Written By Checked & Approved By Re-format; Removed finishing; Material change K Comment J **Additional Product** Job Number: Seq. #: Machine Or Operation: Description: M303R0750 303 Round Bar .75" Comment: Qty.: 0.0810 f(s)/Unit Total: 40.4775 f(s) Material: Ø0.750 AISI 303 SS Rod (M303R0.750) Batch 11/03713/267045 HARDINGE 2.0 Comment: HARDINGE CNC LATHE SMALL Machine as per folio FA198 Deburr and tumble 3.0 INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK PACKAGING 1 PACKAGING RESOURCE #1 5.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

Dart	Aer	ner	1200	e Ltd
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W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			

art No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: 0+1041
			QA: N/C Closed:	Date:

NCR:			WORK ORDER NON-CONFORMANCE (NCR)							
The Westernan		Description of NC		Corrective Action Section B		Verification		Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector		
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1	Ellisticus in							1		
								418		

NOTE: Date & initial all entries

Date: _,

Wednesday, 3/14/2007 3:31:23 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 31224

Part Number: D2570

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



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70764/05

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Dart Aerosp	ace Ltd							
W/O:		WORK ORDER C	HANGES					
DATE ST	EP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								24
								80
Part No:	PAR #: _	Fault Category:	NC	R: Yes	No DQA	:	_ Date: _	
				QA: N	N/C Closed	:	_ Date: _	
NCR:		WORK ORDER NON-CONF	ORMANCE	E (NCF	₹)			
	Description of NC	Corrective Action	Section B		Vorific	ation	Approval	Approval

WORK ORDER NON-CONFORMANCE (NCR)							
Approval	Annrova						
Chief Eng	Approva QC Inspecto						

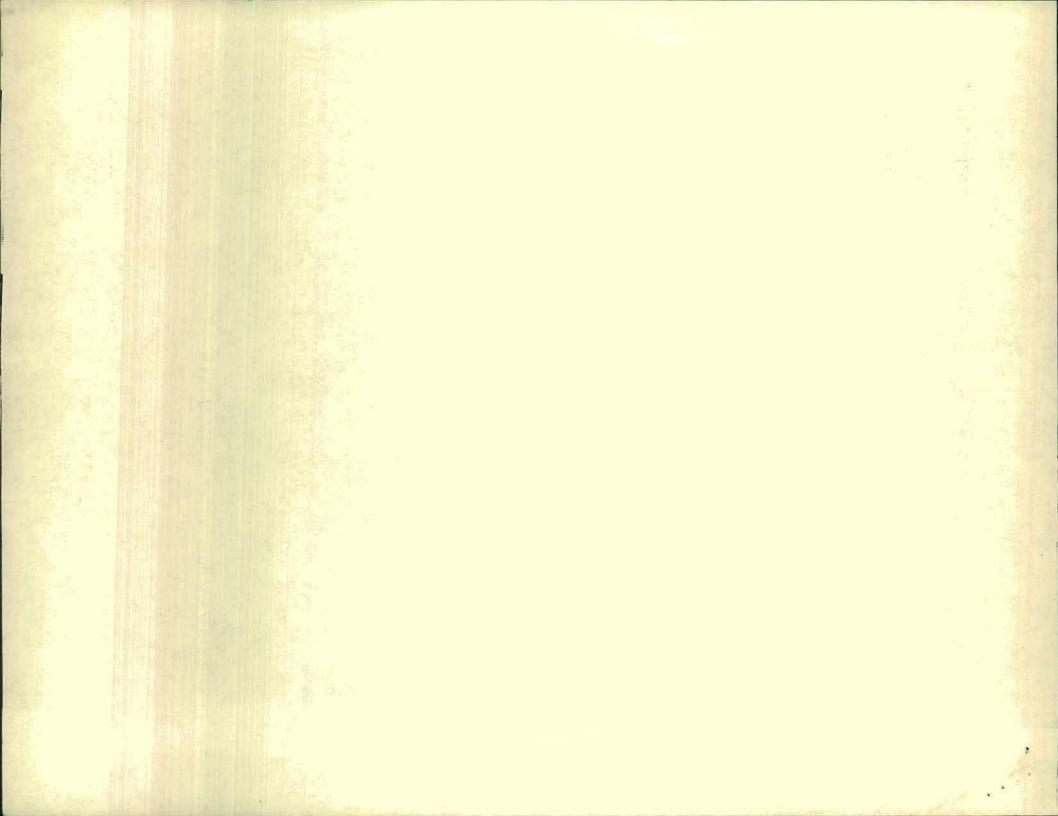
NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31224
Description: Bushing	Part Number:	D2570
Inspection Dwg: D2570 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST X First Article Prototype								
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments		
0.800	+/-0.010	.901	1					
0.060	+/-0.005	.061	1					
R0.010	+0.010/-0.000	.010	1					
Ø0.425	+0.000/-0.002	,424	1					
Ø0.257	+0.005/-0.000	.257	1					
Ø0.750	+/-0.010	7484	1					
0.030 x 20°	+/-0.010	,030 120	/					
-11-								
=======================================								
	1 1							
	0 /							
Measured by:	8 8	Audited by:	M8 /	.20	Prototype Appro	val: N/A		
Date:	07/03/30	Date:	01/03		D	ate:		

Measured by:	Audited by: MS /50	Prototype Approval:	N/A
Date: 07/03/30	Date: 01/03/30	Date:	

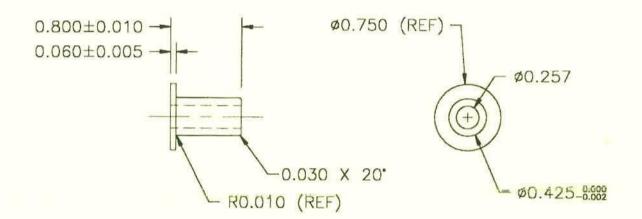
Rev	Date	Change	Revised by	Approved
Α	03.12.08	New Issue	KJ/RF 1.A	
В	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
			()	





DESIGN	DRAWN BY	DART AEROSPACE		
CHECKED	APPROVED	DRAWING NO.		REV. A
A	1	D2570	SHEET	1 OF 1
DATÉ		TILE		SCALE
96:09:16		BUSHING		1:1





BREAK ALL SHARP CORNERS 0.010 MAX MATERIAL: AISI 303 - 0.75 DIA STOCK

SHOP COPY RETURN TO ENGINEERING

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

